

APR 19 2018

P/w

Reprint

Job Set # 36



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

002629

D205-541-045A
Job Sheet 174151



Part No: D205-541-045A

Job Qty: 1 ea

Part Name: Bell Medium Heli-Utility-Basket™ with Automatic Lid Opener, Low Profile - LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/12/18

Job Tracking No:

Due Date: 4/18/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV C IPP REV:A 17.01.23 AS PER CHG002 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/17/18	0.00	0.00	Start Up Small Fab-4		18-4-19
110	Small Fab	1 pcs		4/18/18	0.00	1.33	Small Fab-1		18-4-19
120	QC	1 pcs		4/18/18	0.00	0.00	QC5		23
130	Packaging	1 pcs		4/18/18	0.00	0.00	Packaging1-2		APR 24 2018
140	QC	1 pcs		4/18/18	0.00	0.00	QC4		58
145	DC	1 pcs		4/18/18	0.00	0.00	DC		9-89 DAS
150	Packaging	1 pcs		4/18/18	0.00	0.00	Packaging3-1		58
160	QC21-FG	1 Ea		4/18/18	0.00	0.00	QC21		21 APR 25 2018

Part Op 110 - 1-Install bumper as per dwg D3712 2-Assemble as per IIN 205-541-045, DSI9710

Descriptions: 145 - Photocopy bluefile & type labels per PPPD205-541-045A CHG002

150 - Identify and pack for shipping as per PPP D205-541-045A Location:

PPP Rev:

PAINT 138832



Container No: S062720



Part: D205-541-045A

Job No: 174151

Serial No/Batch: S062720

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/19/18

Job BOM

00 2629

Part / Item	Component Name	Quantity	Operation	Container
AN3-16A	Bolt	2 Ea (2 ea)	90-Start up Operation	5045859
AN4-20A	Bolt	3 Ea (3 ea)	90-Start up Operation	5017061
AN5-17A	Bolt	4 Ea (4 ea)	90-Start up Operation	5019409
D205-541-051	Bell Medium Basket Automatic Lid Opener	1 Ea (1 ea)	90-Start up Operation	5058750
D2530	Handle Weldment	1 Ea (1 ea)	90-Start up Operation	5045772
D2535	Spring	2 Ea (2 ea)	90-Start up Operation	5047890
D2537	Bushing	2 Ea (2 ea)	90-Start up Operation	5043700
D3712-041	Basket Base Assembly	1 Ea (1 ea)	90-Start up Operation	5056510
D3713-041	Lid Assembly	1 Ea (1 ea)	90-Start up Operation	5052049
D3723-1	Bushing	6 Ea (6 ea)	90-Start up Operation	5052209
MS21042L3	Nut	2 Ea (2 ea)	90-Start up Operation	5038764
MS21042L4	Nut	3 Ea (3 ea)	90-Start up Operation	5041167
MS21042L5	Nut	4 Ea (4 ea)	90-Start up Operation	5045855
NAS1149D0463J	Washer	6 Ea (6 ea)	90-Start up Operation	5039036
NAS1149D0563J	Washer	4 Ea (4 ea)	90-Start up Operation	5039036
AN4-12A	Bolt	3 Ea (3 ea)	130-Packaging	5048371
AN4-13A	Bolt	9 Ea (9 ea)	130-Packaging	5045808
AN4-14A	Bolt	2 Ea (2 ea)	130-Packaging	5027723
AN4-7A	Bolt	2 Ea (2 ea)	130-Packaging	FM137820.80
AN5-13A	Bolt	1 Ea (1 ea)	130-Packaging	FM136921
AN5-7A	Bolt	1 Ea (1 ea)	130-Packaging	FM123355
D2199-1	Struts, 19"	1 Ea (1 ea)	130-Packaging	5033309
D2199-23	Strut	1 Ea (1 ea)	130-Packaging	5050229
D2199-25	Strut	1 Ea (1 ea)	130-Packaging	4163813
D2498	Mounting Lug	1 Ea (1 ea)	130-Packaging	5063247
D2499	Mounting Bracket	1 Ea (1 ea)	130-Packaging	5063322
D2515	Bushing	2 Ea (2 ea)	130-Packaging	5160407
D3052-1	Mounting Lug	1 Ea (1 ea)	130-Packaging	5063119
MS21042L4	Nut	16 Ea (16 ea)	130-Packaging	5045901
NAS1149D0432J	Washer	4 Ea (4 ea)	130-Packaging	FM137459-15
NAS1149D0463J	Washer	31 Ea (31 ea)	130-Packaging	5045845
NAS1149D0532J	Washer	2 Ea (2 ea)	130-Packaging	FM131467
NAS1149D0563J	Washer	5 Ea (5 ea)	130-Packaging	5039036

MS21042L5

X2

5041167

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-16A	2	118	0
	AN4-20A	3	212	0
	AN5-17A	4	120	0
	D205-541-051	1	1	0
	D2530	1	20	0
	D2535	2	81	0
	D2537	2	88	0
	D3712-041	1	1	0
	D3713-041	1	1	0
	D3723-1	6	39	0
	MS21042L3	2	2,563	0
	MS21042L4	3	3,873	0
	MS21042L5	4	1,052	0
	NAS1149D0463J	6	5,730	0
	NAS1149D0563J	4	1,794	0
130-Packaging	AN4-12A	3	149	0
	AN4-13A	9	900	0
	AN4-14A	2	201	0
	AN4-7A	2	216	0
	AN5-13A	1	80	0
	AN5-7A	1	3,436	0
	D2199-1	1	9	0
	D2199-23	1	4	0
	D2199-25	1	3	0
	D2498	1	0	0
	D2499	1	1	0
	D2515	2	103	0
	D3052-1	1	0	0
	MS21042L4	16	3,873	0
	NAS1149D0432J	4	328	0
	NAS1149D0463J	31	5,730	0
	NAS1149D0532J	2	160	0
	NAS1149D0563J	5	1,794	0
Part Specifications				
Specifications could not be found.				



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002629	S063139	AN4-12A	Bolt	S048377	ST344	3
002629	S063136	AN4-13A	Bolt	s045860	ST344	9
002629	S063132	AN4-14A	Bolt	S027723	ST344	2
002629	S063127	AN4-7A	Bolt	FM137820.80	ST345	2
002629	S063126	AN5-13A	Bolt	FM136931	ST338	1
002629	S063125	AN5-7A	Bolt	FM123355	OVER009	1
002629	S063140	D2199-1	Struts, 19"	s033309	ST352	1
002629	S063141	D2199-23	Strut	s050229	ST252	1
002629	F163813	D2199-25	Strut		ST352	1
002629	S063098	D2515	Bushing	F160407	ST007	2
002629	S063096	MS21042L4	Nut	s045901	ST303	3
002629	S063124	MS21042L4	Nut	S045901	ST303	13
002629	S062716	MS21042L5	Nut	S041167	Start Up Small Fab-4	2
002629	S063090	NAS1149D0432J	Washer	fm137459-15	ST264	4
002629	S063079	NAS1149D0463J	Washer	s045845	ST263	6
002629	S063123	NAS1149D0463J	Washer	S045845	ST263	25
002629	S063054	NAS1149D0563J	Washer	S039036	ST263	4
002629	S063122	NAS1149D0563J	Washer	S039036	ST263	1

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 4/20/18 8:01 AM Dart.joly.jocelyne

REFERENCE ONLY

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
1*	1*	1*	1*			AN4-22A	BOLT
1*	1*	1*	1*			AN4-24A	BOLT
1	1	1	1			AN5-7A	BOLT
1	1	1	1			AN5-13A	BOLT
4*	4*	4*	4*			AN5-17A	BOLT
				5	5	AN960-10	WASHER (OR NAS1149F0363P) (OPTIONAL)
				20	20	AN960JD10L	WASHER (OR NAS1149D0332J)
2*	2*	6*	6*			AN960JD416	WASHER (OR NAS1149D0463J)
				2	2	AN960-416	WASHER (OR NAS1149F0463P) (OPTIONAL)
27	27	27	27	36	36	AN960JD416	WASHER (OR NAS1149D0463J)
2*	2*	2*	2*	4	4	AN960JD416L	WASHER (OR NAS1149D0416J)
4*	4*	4*	4*			AN960JD516	WASHER (OR NAS1149D0563J)
3	3	3	3			AN960JD516	WASHER (OR NAS1149D0563J)
2	2					AN960JD8	WASHER (OR NAS1149DN832J)
4*	4*	4*	4*			AN970-4	WASHER
2*	2*					MS20600AD4W3	RIVET
2*	2*	2*	2*	8	8	MS21042L3	NUT (OR MS21042-3)
				5	5	MS21042L3	NUT (OR MS21042-3) (OPTIONAL)
4*	4*	5*	5*			MS21042L4	NUT (OR MS21042-4)
16	16	16	16	20	20	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21043L4	NUT (OR MS21043-4)
4*	4*	4*	4*			MS21042L5	NUT (OR MS21042-5)
2	2	2	2			MS21042L5	NUT (OR MS21042-5)

* = ASSEMBLED AT DART

6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

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Revision: J

Date: 10.03.08

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. J AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-541 REV. 4

REF TCCA STC: SH96-120

REF FAA STC: SR00696NY

REF EASA STC: EASA.IM.R.S.01242

PURPOSE:

FOR CUSTOMERS/OPERATORS CONCERNED WITH GAPS AT STA's 84.29, 129.00 AND 155.06 WHILE INSTALLING D205-541-043/-044/-045/-046 BASKETS, IT IS ACCEPTABLE TO FILL THE GAPS WITH WASHERS TO REDUCE UNNECESSARY STRESS ON THE MOUNTING LUGS.

CHANGE:

INSTALL THE D205-541-043/-044/-045/-046 BASKET KITS PER INSTALLATION INSTRUCTIONS D205-541 WITH ADDITIONAL WASHERS AS SHOWN IN FIGURE 1 OF THIS SERVICE INSTRUCTION.

PARTS LIST:

THE PARTS LISTS FOR D205-541-043/-044 AT CHG 003 OR LATER AND D205-541-045/-046 AT CHG 002 OR LATER ARE AMENDED AS FOLLOWS:

25.8 D205-541 INSTALLATION PARTS LIST (ICA-D205-541)**5.2 D205-541-043 INSTALLATION PARTS LIST (D205-541)**

QTY -043	QTY -044	QTY -045	QTY -046	PART NUMBER	DESCRIPTION
X				D205-541-043	HELI-UTILITY-BASKET-LH
	X			D205-541-044	HELI-UTILITY-BASKET-RH
		X		D205-541-045	HELI-UTILITY-BASKET-LH
			X	D205-541-046	HELI-UTILITY-BASKET-RH

ADD:

4	4	4	4	NAS1149D0463J	WASHER
4	4	4	4	NAS1149D0432J	WASHER
2	2	2	2	NAS1149D0532J	WASHER
2	2	2	2	NAS1149D0563J	WASHER

WEIGHT AND BALANCE:

THERE IS NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

MAINTENANCE:

PER ICA-D205-541.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.11.27

CERT. NO.: SH96-120

ISSUE NO.: 3

A	NEW ISSUE	DW	14.11.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9667	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WASHER ADDITION	NTS
DATE	14.11.27	COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-541-043 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	- 63.13 in - 1.60 m	- 7449 in-lb - 85.8 m-kg	132.25 in 3.36 m	15606 in-lb 180.1 m-kg
D205-541-044 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	+ 63.13 in + 1.60 m	+ 7449 in-lb + 85.8 m-kg	132.25 in 3.36 m	15606 in-lb 180.1 m-kg
D205-541-045 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	- 63.13 in - 1.60 m	- 6566 in-lb - 75.7 m-kg	132.25 in 3.36 m	13754 in-lb 158.9 m-kg
D205-541-046 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	+ 63.13 in + 1.60 m	+ 6566 in-lb + 75.7 m-kg	132.25 in 3.36 m	13754 in-lb 158.9 m-kg
D205-541-047 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	- 76.11 in - 1.93 m	- 1066 in-lb - 12.4 m-kg	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kg
D205-541-048 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	+ 76.11 in + 1.93 m	+ 1066 in-lb + 12.4 m-kg	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kg
D205-541-141 <i>Heli-Utility-Basket™</i>	69 lb 31.4 kg	- 59.9 in - 1.5 m	- 4133 in-lb - 47.1 m-kg	161.6 in 4.1 m	+ 11150 in-lb + 128.7 m-kg
D205-541-142 <i>Heli-Utility-Basket™</i>	69 lb 31.4 kg	+ 59.9 in + 1.5 m	+ 4133 in-lb + 47.1 m-kg	161.6 in 4.1 m	+ 11150 in-lb + 128.7 m-kg

5.0 PARTS LIST HELI-UTILITY-BASKET™

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
X						D205-541-043	HELI-UTILITY-BASKET, LH
	X					D205-541-044	HELI-UTILITY-BASKET, RH
		X				D205-541-045	HELI-UTILITY-BASKET, LH
			X			D205-541-046	HELI-UTILITY-BASKET, RH
				X		D205-541-141	HELI-UTILITY-BASKET, LH
					X	D205-541-142	HELI-UTILITY-BASKET, RH
				1	1	DSI 9302-011	STRUT MODIFICATION KIT (FOR D205-633 STEP INSTALLATION)
2*	2*					D2022-101	SPACER
				2	2	D2022-101	SPACER (FOR D205-633 STEP INSTALLATION)
1	1	1	1			D2199-1	STRUT
1	1	1	1			D2199-23	STRUT
1	1	1	1			D2199-25	STRUT
1*	1*	1*	1*			D2258-300	LABEL
1*	1*	1*	1*			D2332-041	PROP ASSEMBLY
				1	1	D2332-041	PROP ASSEMBLY (OPTIONAL)
				1	1	D2464-0410	NEOPRENE SEAL
1	1	1	1			D2498	MOUNTING LUG
1	1	1	1			D2499	MOUNTING LUG
1*	1*					D2512	BASKET LID ASSEMBLY

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
2	2	2	2			D2515	BUSHING
1*	1*	1*	1*			D2530	HANDLE ASSEMBLY
2*	2*	2*	2*			D2535	SPRING
2*	2*	2*	2*			D2537	BUSHING
2*	2*					D2931	BUMPER
1	1	1	1			D3052-1	MOUNTING LUG
1*						D3053-041	BASKET BASE ASSEMBLY, LH
	1*					D3053-042	BASKET BASE ASSEMBLY, RH
		1*				D3712-041	BASKET BASE
			1*			D3712-042	BASKET BASE
		1*				D3713-041	LID ASSEMBLY
			1*			D3713-042	LID ASSEMBLY
		6*	6*			D3723-1	BUSHING
				2	2	D3953-9	GAS SPRING SPACER (OPTIONAL)
				1		D4041-011	SHORT BASKET ASS'Y, LH
					1	D4041-012	SHORT BASKET ASS'Y, RH
				1		D4048-041	MOUNTING LUG ASS'Y
					1	D4048-042	MOUNTING LUG ASS'Y
				1		D4048-5	MOUNTING LUG
					1	D4048-6	MOUNTING LUG
				1		D4048-7	MOUNTING LUG
					1	D4048-8	MOUNTING LUG
				6	6	D4048-9	BUSHING
				1		D4049-041	MOUNTING LUG ASS'Y
					1	D4049-042	MOUNTING LUG ASS'Y
				1		D4049-5	MOUNTING LUG
					1	D4049-8	MOUNTING LUG
				1	1	D4050-1	STRUT
				1	1	D4050-3	STRUT
				1		D4050-5	STRUT
					1	D4050-8	STRUT
				1		D4051-041	GUARD (OPTIONAL)
					1	D4051-042	GUARD (OPTIONAL)
				2	2	D4052-1	EYE BOLT
				10	10	AN3-5A	BOLT
				1	1	AN3-7A	BOLT (OPTIONAL)
				4	4	AN3-11A	BOLT (OPTIONAL)
2*	2*	2*	2*			AN3-16A	BOLT
				5	5	AN4-6A	BOLT
2*	2*					AN4-7A	BOLT
2	2	2	2	1	1	AN4-7A	BOLT
3	3	3	3	2	2	AN4-12A	BOLT
9	9	9	9			AN4-13A	BOLT
2	2	2	2	11	11	AN4-14A	BOLT
				1	1	AN4-16A	BOLT
		3*	3*			AN4-20A	BOLT

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Revision: J

Date: 10.03.08

Change Record

PAGE 1 OF 1

Part Number: D205-541-045A/-046A

Description: HELI UTILITY BASKET, LH/RH, w/ AUTOMATIC LID OPENER

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					